Work Ordo		•	·	*961	137*						Page 1
Item ID: Revision ID: Item Name:	D3255-5 Gasket			Accept	*N900	040	100)* s	Setup Start	1 71	S1* S2*
Start Date: Required Date: Reference:	1/21/13 : 2/05/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:					
Approvals:		in: MC5		•		ate:		1	Run Start Stop	1/1	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	rision Nbr									-
D3255	Rev	В									
*100 *100*		FLOW WATER JET		0.00			And Mark Co. Company of the State Section Co.	4	_6_		Jm13-2-6
Waterjet FLOW CNC Water	jet Gasket	Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if		0.00							
*110 *11 0 *		QC2- Inspect parts off m	achine FAI/FAIB	0.00				¥	۵		Im 13-2-6
QC		Memo		0.00							<u> </u>

Quality Control

		,	
NCR:	Yes	/	No

DQA: _____Date: ____

NCR: Y	es / No				WORK ORDER NON-C	ONFOR	WIANCE / UP	DAIL	QA Closed:	Date	: :
Work Orde	r·				DISPOSITION		···	AGAINST DE	PARTMENT	PROCESS	
Part N			Scrap Machining Small Fab Prod. Eng. Coor. Qua						Engineering Quality		
NCR N	o				Use-as-is Work Order Update	Thermoforming Finishing Rec/Store/Packaging Othe Large Fab Composite Supplier					
Root					ption of work order update	Initial	.	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc.	cription	Date	Verification	QC Inspector
Doc/Data	_										
Equip/Tooling										٠	
Operator	_]]
Material											
Setup											
Other Process											
Supplier	\dashv						İ				
Training	-	ļ									
Unapproved					•						
	!	1			F	AULT CAT	EGORY			·-	•
Landin	ng Gear				General						
ſ	Bending				Bend	Grain			Ovalized		Pressure/Forced
[Centre No	ot Conce	ntric to C	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
[Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct [Weld
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete	/Unclear	Part Lost/M	issing [Wrong Stock Pulled
1	Cuffs				Contamination	\mapsto	enance		Part Moved		
1	Heat Trea	at			Countersink	Mislak			Positioned \	, ,	\neg
1	Inspectio		Tube		Cut Too Short	Misre			Power Loss/	'Surge	Other
ļ	Ripples in				Drill Holes	Offset			•		
1	Torque W			` <u> </u> _	Drawing		Calibration				
1	Turning S				Finish	\vdash	Sequence				. And the state of
į.	Wave/Tw	vist in Tul	st in Tube Folio Outside Dimensions								

January-23-13	10:05:18 AM										
Item ID: Revision ID: Item Name:	D3255-5 Gasket			Accept	*N900	040 <i>°</i>	100)* s	etup Star	ı V	S1*
Start Date: Required Date: Reference:	1/21/13 2/05/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:				1 4	
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:		R	tun Star	171	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	` *N	R2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	d check	Set Up/ Run Hours 0.00 SmB 0.00 /3-2-7	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* Packaging Packaging		Identify as per dwg & Stoo Memo	k Location:	0.00				<u> </u>	[J;] 3/5/-{	~- (Y-)
140 *140* QC Quality Control		QC21- Final Inspection - \frac{1}{Memo}	Work Order Release	0.00					13,	12/11	1)
									٨	1209	// ~

NCR:	Yes	1	No

DQA: _____Date: ____

NCR: Y	es / No				WORK ORDER NON-	CONFORI	MANCE / UP		QA Closed:	Date	:	
Work Orde	Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS											
	Rework Skid-tube Crosstube Water Jet Part No. Scrap Machining Small Fab Prod. Eng. Coor.						d. Eng. Coor.	Engineering Quality Other				
NCR N	lo				Use-as-is Work Order Update	Therr	Thermoforming Finishing Rec/Store/Packaging Composite Supplier					
Root				Descri	ption of work order update	Initial	ļ.	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling	_									,		
Operator												
Material												
Setup Other	_	ļ										
Process	-											
Supplier												
Training												
Unapproved												
			<u> </u>		F	AULT CATE	GORY					
Landir	ng Gear				General				•	_		
	Bending				Bend	Grain			Ovalized		Pressure/Forced	
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardw			Over/Under	⊢	Temperature/Cure	
٠	Cracks			ļ	Broken/Damaged		tion ncomplete	_	Part Incorre	 	Weld	
	Crushed/	Crimped.		<u> </u>	Burrs	 	tions Incomplete,	/Unclear	Part Lost/M		Wrong Stock Pulled	
-	Cuffs			-	Contamination	├ ──	enance	<u> </u>	Part Moved			
]	Heat Trea		 .	-	Countersink	Mislab		<u> </u>	Positioned \		Other	
	Inspectio		Tube	-	Cut Too Short	Misrea Offset	a ·	<u>L</u>	Power Loss/	Surge [Tomer	
ŀ	Ripples in Torque V		Evtrucia	<u> </u>	Drill Holes Drawing		Calibration					
	·	vaves in i Sequence		''	Finish	\vdash	Sequence				· · · · · · · · · · · · · · · · · · ·	
	Wave/Tv	•			Folio	—	e Dimensions					
	10000/10				1. 55	1 1 2 2 3 3 7 6 1					· · · · · · · · · · · · · · · · · · ·	

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

January-23-13 10:05:18 AM

Work Order ID:

96137

Parent Item:

D3255-5

Parent Item Name:

Gasket

Start Date: 1/21/13

Required Date: 2/05/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP A04.05.12New issueKJ/RF

IPP Rev:B Now On Wateriet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255		Manufactured	No			110	sf	17.5000	1.5411	3244421			
Gasket										6			<u> </u>

 Location
 Loc Oty
 Loc Code

 MAT052
 17.5

 83847
 17.5

83847

NCD	W	,	
NCR:	Yes	1	No

DQA: Date:

NCR: Y	es / No				WORK ORDER NON-C	CONFOR	MANCE / UP	DAIE	QA Closed:	Date	:
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No. Scrap Machining Small Fab Prod. Eng. Cook						-	Engineering Quality				
NCR N	o				Use-as-is Work Order Update	Thermoforming Finishing Rec/Store/Packaging Othe Large Fab Composite Supplier					
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	_								 		
Equip/Tooling									ļ		
Operator											
Material											
Setup]
Other											
Process	_	1	,			1			1		
Supplier		i i									
Training										ĺ	
Unapproved		<u>l</u>	<u>l</u>		F	AULT CATI	GORY		<u> </u>	<u> </u>	
Landin	ng Gear				General						
	Bending				Bend	Grain			Ovalized	Γ	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
ľ	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
ľ	Crushed/	Crimped			Burrs	-	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
Ī	Cuffs	•			Contamination		enance		Part Moved	_	
ľ	Heat Trea	at		<u> </u>	Countersink	Mislab	eled		Positioned \	Wrong .	
ļ	Inspectio		Tube		Cut Too Short	Misrea	ıd		Power Loss,	'Surge	Other
Ī	Ripples in				Drill Holes	Offset			-		
ļ	Torque W		Extrusio	1	Drawing	Out of	Calibration				
Ī	Turning S	equence	!		Finish	Out of	Sequence				
	Wave/Tw	vist in Tu	be		Folio	Outsid	e Dimensions				

DART AEROSPACE LTD	Work Order:	96137
Description: Gasket	Part Number:	D3255-5
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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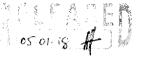
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.00"	_		υ	JLmoi
18.46	+/-0.030	18.46	-		T	Jemos Jemos Produzez
11.43	+/-0.030	11.43	-		V	Produger
15.36	+/-0.030	15.36	-		7	
6.90	+/-0.030	6.900	_		V	
0.063	+/-0.010	0.063			✓	
-						

Measured by: Jm	Audited by: SMA	Prototype Approval:	N/A
Date: 13-2-6	Date: 13-2.7	' Date:	N/A

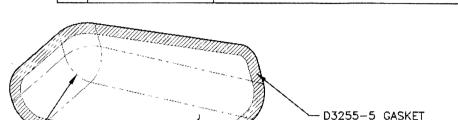
	Rev	Date	Change	Revised by	Approved	
Γ	Α	07.07.18	New Issue	KJ/JLM	B	
_				7 (1)		



DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	(ED	APPROVED	DRAWING NO. REV. B
	W	-	D3255 SHEET 1 OF 4
DATE			TITLE SCALE
 04.1	2.06		ACCESS PANEL ASSEMBLY 1:6
Α		04.01.27	NEW ISSUE
В		04.12.06	D3255-3 REDESIGN; ADDED Ø0.098

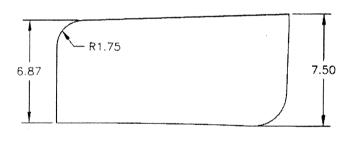


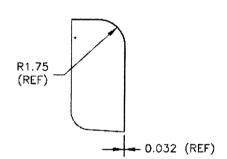
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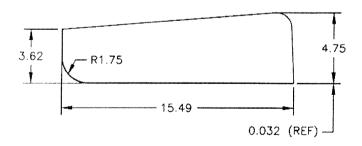


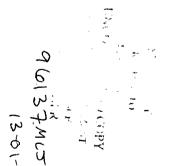
D3255-1 PANEL (SHOWN) D3255-2 PANEL (OPPOSITE)

D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)









D3255-1 BEND DETAIL D3255-2 OPPOSITE

<u>D3255-041/-042 NOTES:</u>
1) WELD PER DART QSI 004

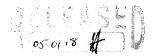
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

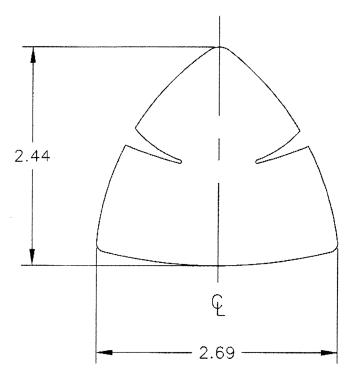
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DESIGN	DRAWN BY		ROSPACE LTD y, ontario, canada
CHECKED	APPROVED	DRAWING NO.	REV. B
4	W-	D3255	SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES

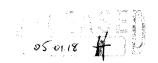
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

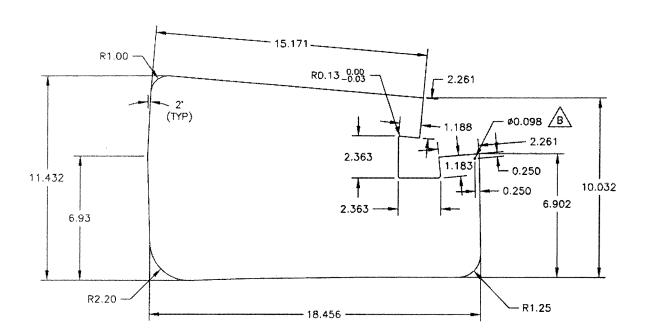
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CHECKED	APPROVED -	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE	-1	TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

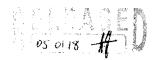
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

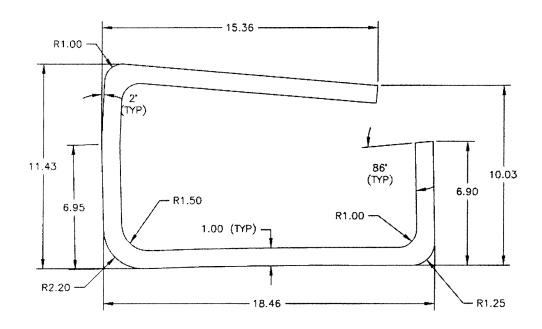
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CHECKED (APPROVED	D3255	REV. B SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

- D3255-5 NOTES:
 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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